

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2014-90 Date Opened: 15 Dec 2014 Title: FabricationAircraft OEM: Bell Aircraft Model: 212 Product Type: High Beams Product Model: N/A Quantity: 13 pair**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

N/A
N/A
JR
JR
N/A
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100632	0	Fwd Beam	JR
100633	0	Aft Beam	JR
100635	0	Strut Fabrication	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

3
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tags Completed
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
JR
JR

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 11-Dec-14

ICC / Dual Inspection performed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 11-Dec-14

Work Order closed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 06-Feb-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0013
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2014-90
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	RH Forward Beam	100632-01-02	1	N/A	New
2.	RH Aft Beam	100633-01-02	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 09 Jan 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

EAGLE COPTERS S.A.



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 100633-01-02
Aircraft: Bell
Description: RH Aft Beam
Supplier: Aero Design
Color: N/A
WO#: 2014-90

Model: 212

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 100632-01-02

Aircraft: Bell

Model: 212

Description: RH Fwd Beam

Supplier: Aero Design

Color: N/A

WO#: 2014-90

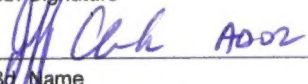
PO# N/A



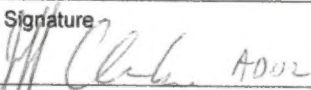
WO# _____

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2014-90	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	RH Forward Beam	100632-01-02	1	N/A	New	
	RH Aft Beam	100633-01-02	1			
	Forward Strut	100635-01	1			
	Aft Strut	100635-02	1			
	Drag Link	100635-03	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 06 Feb 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Ascent

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2014-90	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	RH Forward Beam	100632-01-02	1	N/A	New	
	RH Aft Beam	100633-01-02	1			
	Forward Strut	100635-01	1			
	Aft Strut	100635-02	1			
	Drag Link	100635-03	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			<input type="checkbox"/> Other regulation specified in block 12			
<input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 19 June 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

GUARDIAN

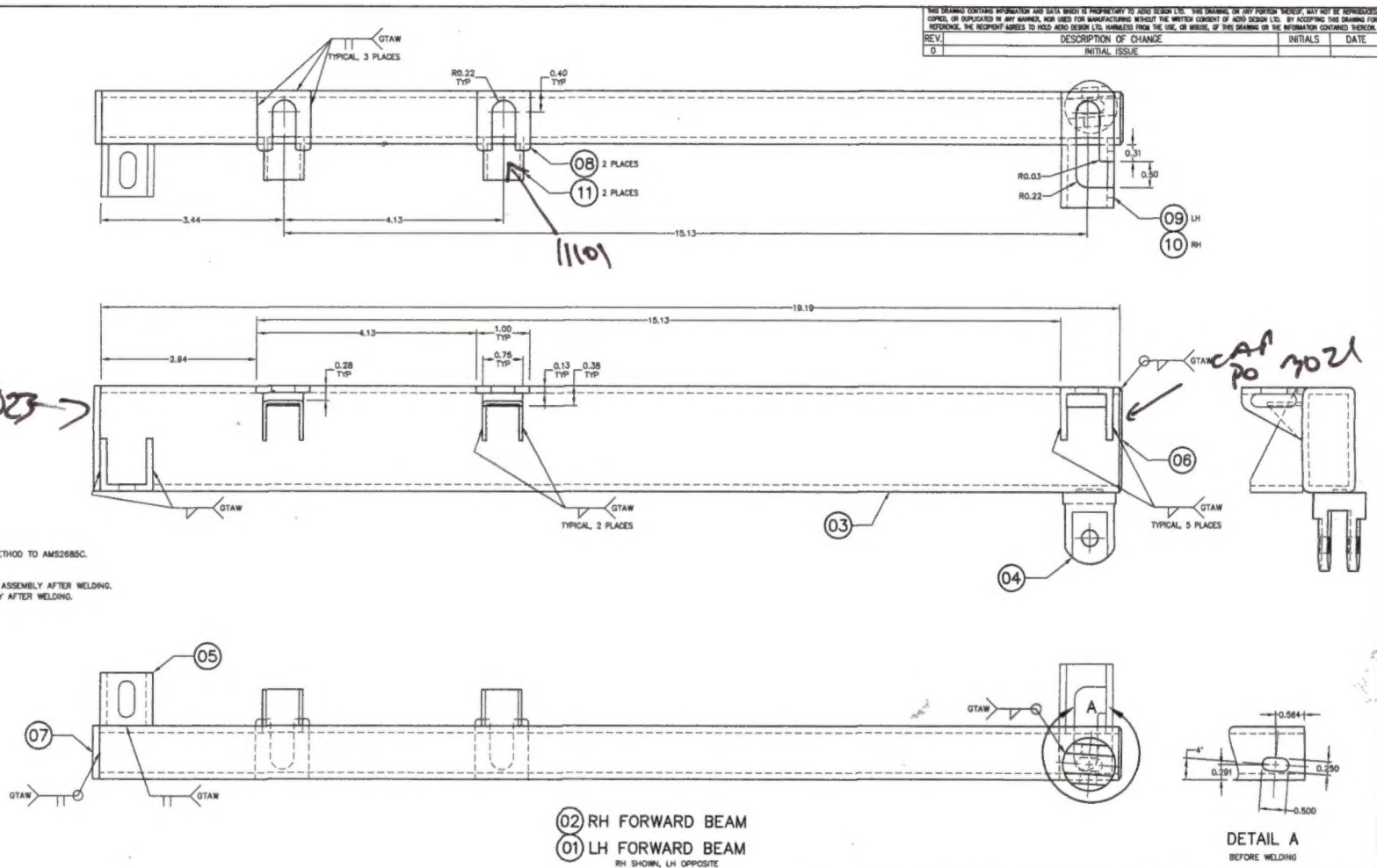
1/8 x 1 flat bar 14023

X3

WO 2014-90

1x2 x 1/8


PO 14060



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2085C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ASSEMBLY AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ASSEMBLY AFTER WELDING.

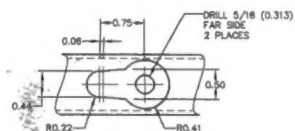
φ 1.0 304 9501112

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	78633-05	11	STOP BRACKET	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SQB. TUBE
1	78633-04-02	10	LH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	78633-04-01	09	RH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
2	78633-03	08	GUIDE	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	100630-06	06	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	100630-05	05	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	100630-04	04	FITTING	304 STAINLESS STEEL	ASTM A479	#1.0 ROD
1	100630-03	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	100632-01-02	02	RH FORWARD BEAM (HIGH MOUNT)			
1	100632-01-01	01	LH FORWARD BEAM (HIGH MOUNT)			
Q2	Q1	QTY	QTY	LIST OF MATERIALS		
APPROVALS			DATE	 AERO DESIGN LTD. 9008A MALASPINA ROAD POWELL RIVER, BC, CANADA, V0A 0G3 TEL: 604.688.8276 www.aerodesign.ca		
DRAWN: JEFF CLARKE			26 NOV 2014			
CHECKED: JASON REKVE			27 NOV 2014			
UNLESS OTHERWISE SPECIFIED			DIMENSIONS ARE IN INCHES.	BELL 205, 212, 214, 412 SERIES EXTERNAL ATTACHMENT PROVISIONS FORWARD BEAM FABRICATION (HIGH MOUNT)		
TOLERANCES ON:			DECIMALS			
			ANGLES			
			±1/2"			
			±0.010	SCALE 1 : 1		
			±0.03	SHEET 1 OF 1		
			±0.1	A1 100632 0 B		

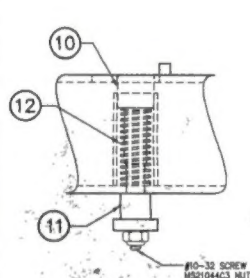
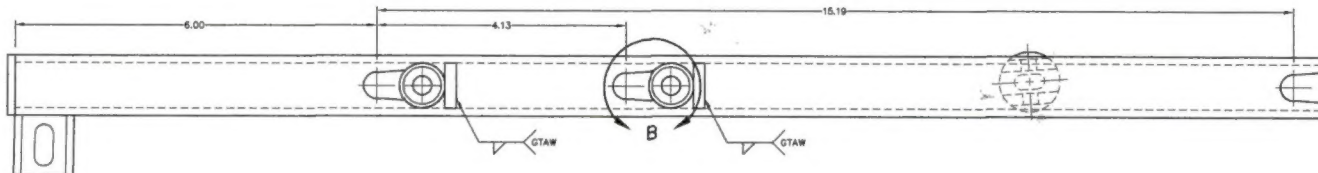
X+2.8073
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13 WO 2014-90

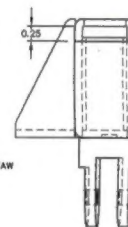
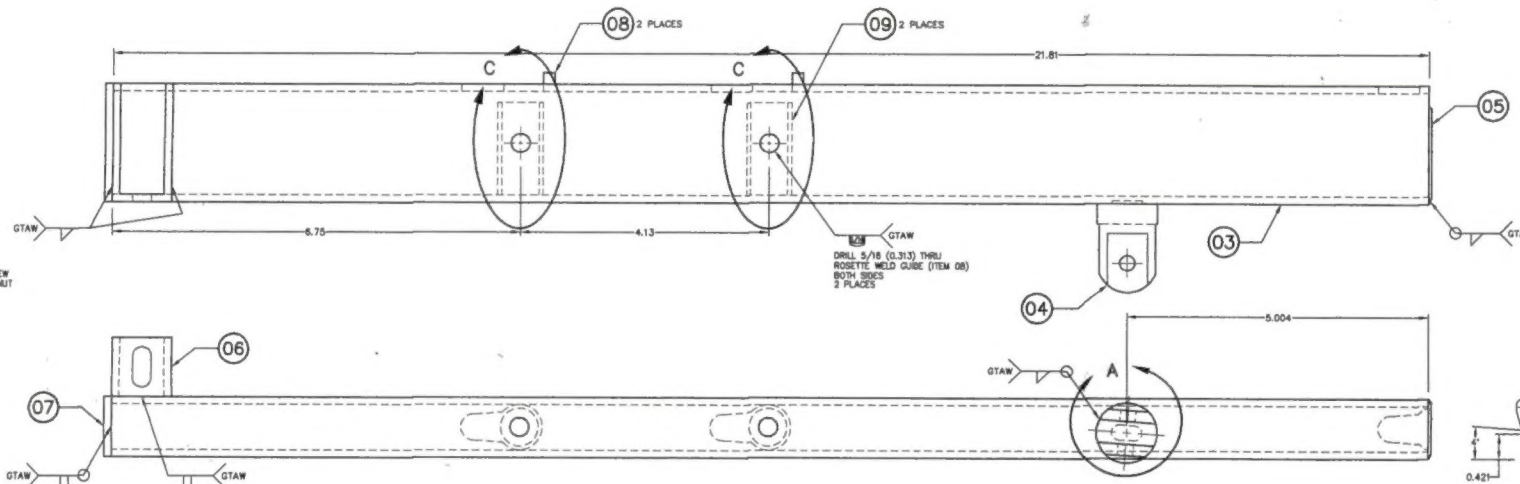
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REVIEW, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



DETAIL B
TYPICAL ALL KEYWAYS



DETAIL C
ASSEMBLY AFTER FINISHING
TYPICAL 2 PLACES




DETAIL A
BEFORE WELDING
SLOT 0.08 DEEP

02 RH AFT BEAM
01 LH AFT BEAM
RH SHOWN, LH OPPOSITE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ASSEMBLY AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ASSEMBLY AFTER WELDING.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	MS21044C3	NUT		STAINLESS STEEL	COMMERCIAL	
2	69830-1032 X 3	C/SUNK SCREW		STAINLESS STEEL	COMMERCIAL	15mm x 70mm SPRING
2	69830-12	SPRING		STAINLESS STEEL	COMMERCIAL	15mm x 70mm SPRING
2	69830-22	11 KNOB		6061-T6 ALUMINUM	00-A-200/8	#0.75 ROD
2	69830-21	10 STOP		6061-T6 ALUMINUM	00-A-200/8	#0.625 ROD
2	69830-11	09 GUIDE		304 STAINLESS STEEL	ASTM A286	#0.75 X 0.065 RND. TUBE
1	69830-07	08 BLOCK		304 STAINLESS STEEL	ASTM A479	0.188 SQ. ROD
1	100630-07	07 CAP		304 STAINLESS STEEL	ASTM A420	1.0 X 0.125 BAR
1	100630-05	06 BRACKET		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	100631-05	05 CAP		304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	100631-04	04 FITTING		304 STAINLESS STEEL	ASTM A479	1.0 ROUND BAR
1	100633-03	03 TUBE		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	100633-01-02	02 RH AFT BEAM (HIGH MOUNT)				
1	100633-01-01	01 LH AFT BEAM (HIGH MOUNT)				

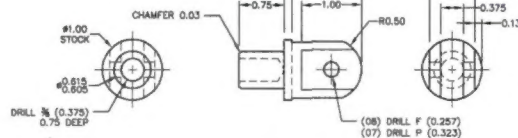
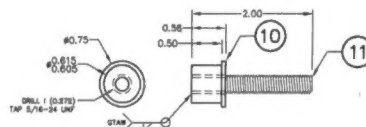
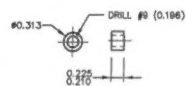
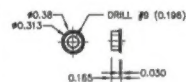
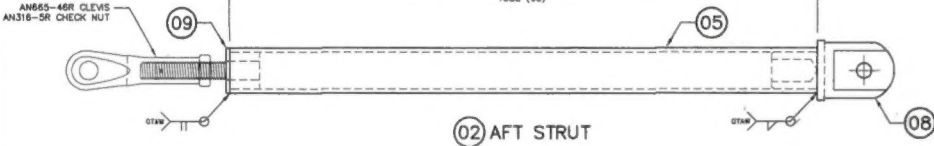
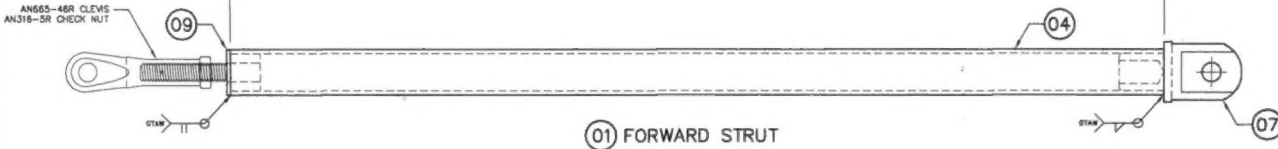
APPROVALS		DATE		AERO DESIGN LTD.	
DRAWN:	JEFF CLARKE	28 NOV 2014		9090A MALAPRISA ROAD	
CHECKED:	JASON REKVE	27 NOV 2014		POWELL BLVD, INC. CANADA, YOA 0G3 TEL: 416-461-6374 www.aerodesign-ltd.ca	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			BELL 205, 212, 214, 412 SERIES EXTERNAL ATTACHMENT PROVISIONS AFT BEAM FABRICATION (HIGH MOUNT)		
DECIMALS		ANGLES			
X.XXX ±0.010		±1/2°			
X.XX ±0.03					
X.X ±0.1					
SCALE 1 : 1			SIZE	DEL.	REV.
SHEET 1 OF 1			A1	100633	0 B

AERO DESIGN LTD.
8800A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604-685-8276
www.aerodesign.ca

BELL 205, 212, 214, 412 SERIES
EXTERNAL ATTACHMENT PROVISIONS
AFT BEAM FABRICATION (HIGH MOUNT)

φ30
φ1.0 304 9501112

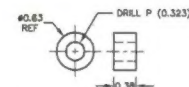
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		




Q7 AND Q8 IDENTICAL EXCEPT FOR HOLE AS NOTED

NOTES

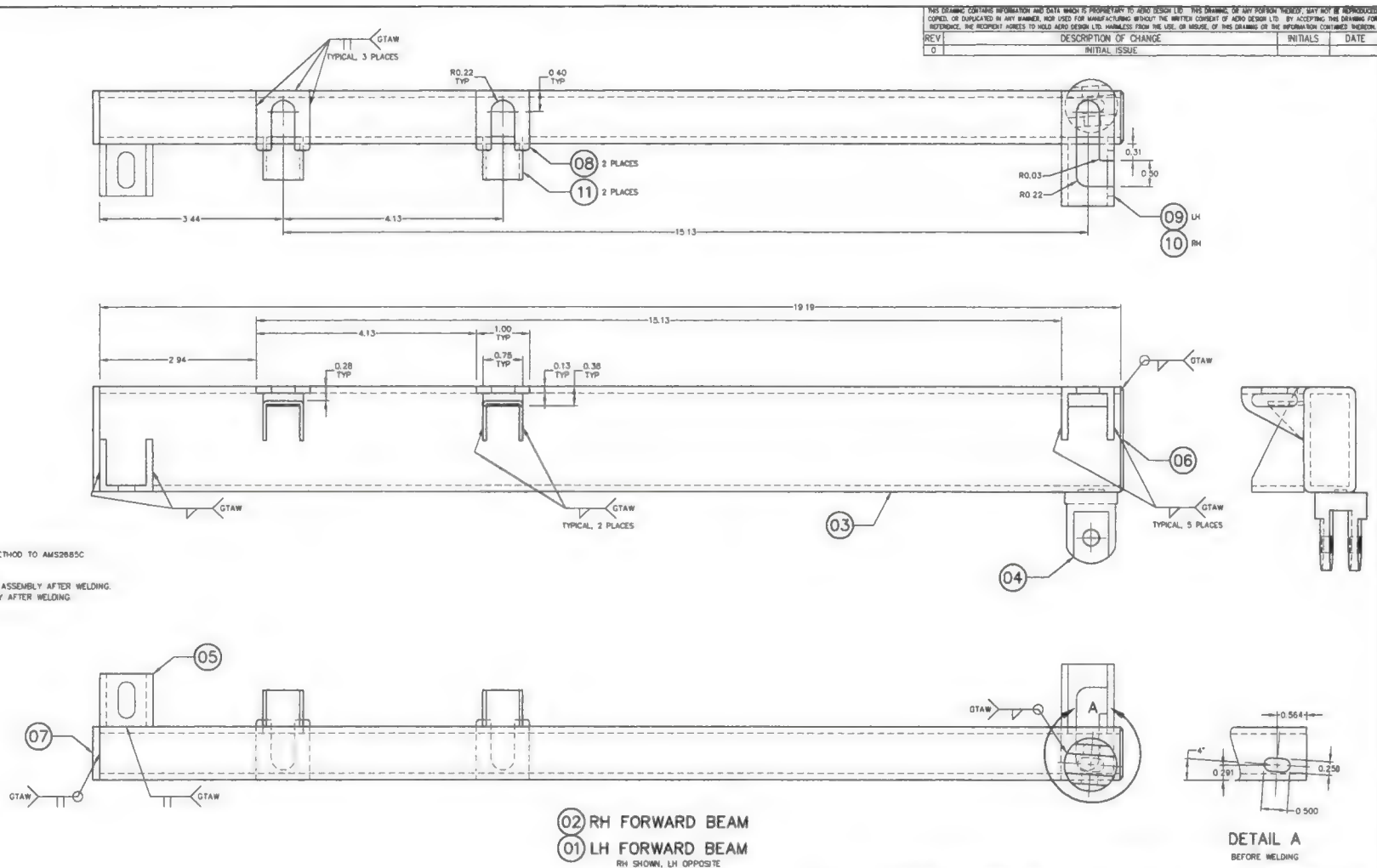
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ALL PARTS AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL PARTS AFTER WELDING. DO NOT PAINT/POWDER COAT THREADED RODS. ASSEMBLE HARDWARE AFTER PAINT/POWDER COAT.



⑭ BUSHING

	2	1	1	AN515-	CHECK NUT				
	2	1	1	AN665-48R	CLEVIS ROD END				
				100K35-14	14 BUSHING	304 STAINLESS STEEL	ASTM A479	#0.825 ROD	
				100K35-13	13 BUSHING	BRASS	ASTM B927	#0.313 ROD	
				100K35-12	12 BUSHING	BRASS	ASTM B927	#0.375 ROD	
1				100K35-11	11 THREADED ROD	304 STAINLESS STEEL	ASTM F593	5/16-24 THREADED ROD	
1				100K35-10	10 THREADED BUSHING	304 STAINLESS STEEL	ASTM A479	#0.75 ROD	
1	2	1	1	100K35-09	THREADED ROD END				
				100K35-08	08 FITTING	304 STAINLESS STEEL	ASTM A479	#1.0 ROD	
				100K35-07	07 FITTING	304 STAINLESS STEEL	ASTM A479	#1.0 ROD	
1				100K35-06	06 TUBE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.085 RND. TUBE	
				100K35-05	05 TUBE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.085 RND. TUBE	
				100K35-04	04 TUBE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.085 RND. TUBE	
				100K35-03	03 DRAG LINK				
				100K35-02	02 AFF STRUT				
				100K35-01	01 FORWARD STRUT				
08	03	02	01	PART NO.	ITEM	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	QTY	QTY	QTY						
						LIST OF MATERIALS			
APPROVALS						DATE			
DRAWN: JEFF CLARKE						24 NOV 2014			
CHECKED: JASON REJIVE						27 NOV 2014			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:									
DECIMALS					ANGLES				
X.XXX ±0.010					±1/2°				
X.XX ±0.03									
X.X ±0.1									
						AERO DESIGN LTD.			
						9060A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8B 0G5 TEL: 604-688-8271			
						BELL 205, 212, 214, 412 SERIES EXTERNAL ATTACHMENT PROVISIONS STRUT FABRICATION			
SCALE 1 : 1						DWG. NO.	REV.	QTY.	ORL.
SHEET 1 OF 1						A1	100635	0	B

FINAL



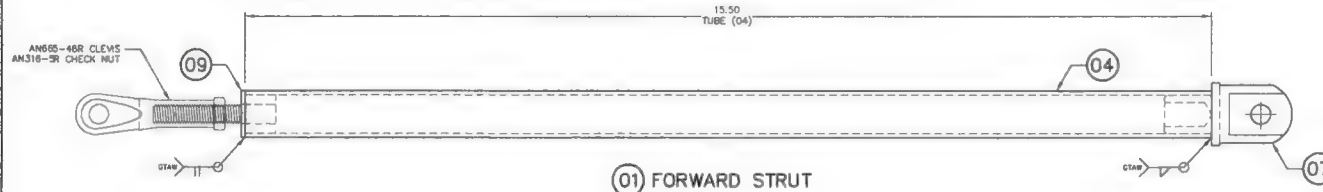
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
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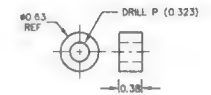
QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	2	78633-05	11	STOP BRACKET	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SCH. TUBE
1	1	78633-04-02	10	LH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	78633-04-01	09	RH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
2	2	78633-03	08	GUIDE	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-06	06	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	100630-05	05	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100630-04	04	FITTING	304 STAINLESS STEEL	ASTM A479	#10 ROD
1	1	100632-03	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100632-01-02	02	RH FORWARD BEAM (HIGH MOUNT)			
1	1	100632-01-01	01	LH FORWARD BEAM (HIGH MOUNT)			

APPROVALS		DATE			AERO DESIGN LTD.		
DRAWN:	JEFF CLARKE	18 DEC 2014			8005A MALASPONA ROAD		
CHECKED:	JASON REKVE	18 DEC 2014			POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604 453 3376 www.aerodesign.ca		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:					BELL 205, 212, 214, 412 SERIES QUICK RELEASE MOUNTING PROVISIONS FORWARD BEAM FABRICATION (HIGH MOUNT)		
DECIMALS		ANGLES					
X.XXX ±0.010		±1/2°					
X.XX ±0.03							
X.X ±0.1							
SCALE 1 1				DWG SIZE	DWG NO	REV	
SHEET 1 OF 1				A1	100632	0	

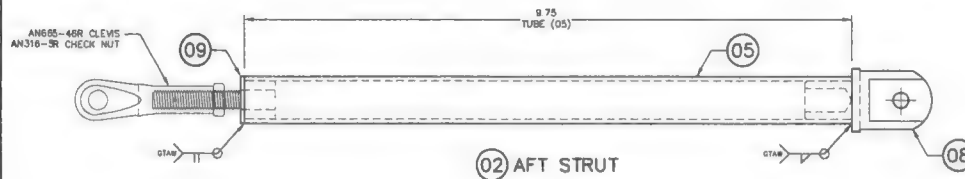
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



01 FORWARD STRUT



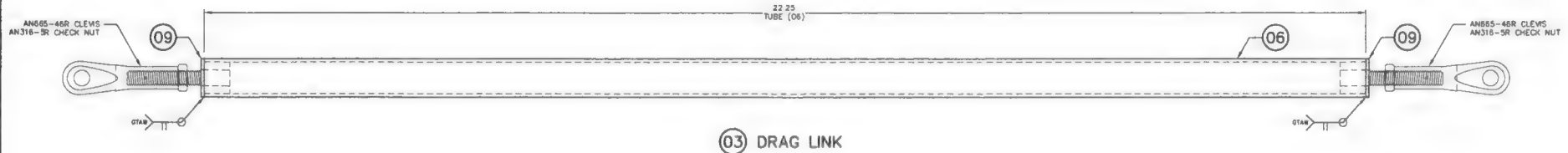
14 BUSHING



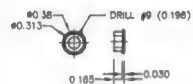
02 AFT STRUT

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ALL PARTS AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL PARTS AFTER WELDING. DO NOT PAINT/POWDER COAT THREADED RODS. ASSEMBLE HARDWARE AFTER PAINT/POWDER COAT.



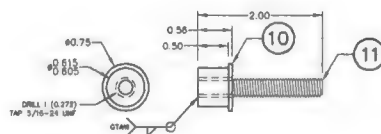
03 DRAG LINK



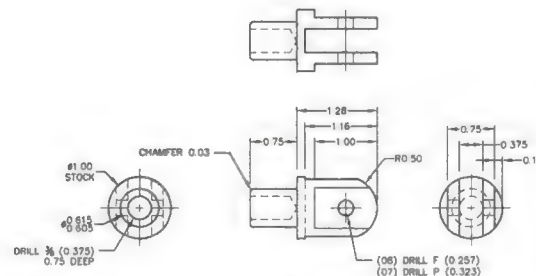
12 BUSHING



13 BUSHING



09 THREADED ROD END



08 FITTING

07 FITTING

07 AND 08 IDENTICAL EXCEPT FOR HOLE AS NOTED

QTY	QTY	QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	1	1		AN315-5R	CHECK NUT				
2	1	1		AN65-46R	CLEVIS ROD END				
			1	100635-14	BUSHING		304 STAINLESS STEEL	ASTM A479	Ø0.625 ROD
			1	100635-13	BUSHING		BRASS	ASTM B927	Ø0.313 ROD
			1	100635-12	BUSHING		BRASS	ASTM B927	Ø0.375 ROD
1			1	100635-11	THREADED ROD		304 STAINLESS STEEL	ASTM F563	5/16-24 THREADED ROD
1			1	100635-10	THREADED BUSHING		304 STAINLESS STEEL	ASTM A479	Ø0.75 ROD
2	1	1		100635-09	THREADED ROD END				
			1	100635-08	FITTING		304 STAINLESS STEEL	ASTM A479	Ø1.0 ROD
			1	100635-07	FITTING		304 STAINLESS STEEL	ASTM A479	Ø1.0 ROD
1			1	100635-06	Ø5 TUBE		304 STAINLESS STEEL	ASTM A269	Ø0.75 X 0.085 RND TUBE
1			1	100635-05	Ø5 TUBE		304 STAINLESS STEEL	ASTM A269	Ø0.75 X 0.085 RND TUBE
1			1	100635-04	Ø4 TUBE		304 STAINLESS STEEL	ASTM A269	Ø0.75 X 0.085 RND TUBE
			1	100635-03	DRAG LINK				
			1	100635-02	Ø2 AFT STRUT				
			1	100635-01	Ø1 FORWARD STRUT				

LIST OF MATERIALS

APPROVALS

DATE

18 DEC 2014

18 DEC 2014

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:

DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.05
X.X ±0.1

AERO DESIGN LTD.

9808A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604-685-3376

BELL 205, 212, 214, 412 SERIES
QUICK RELEASE MOUNTING PROVISIONS
STRUT FABRICATION

SCALE 1:1 DWG SIZE SHEET NO REV

SHEET 1 OF 1 A1 100635 0

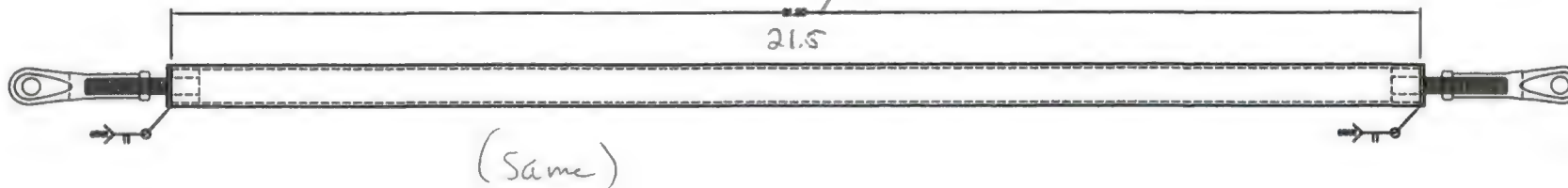
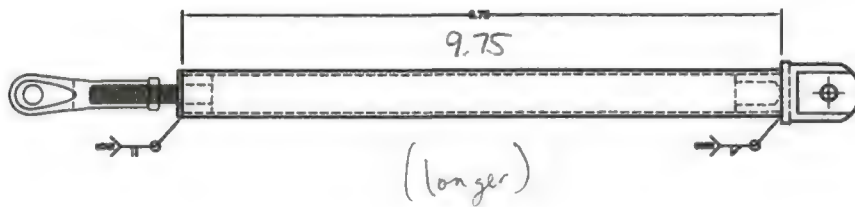
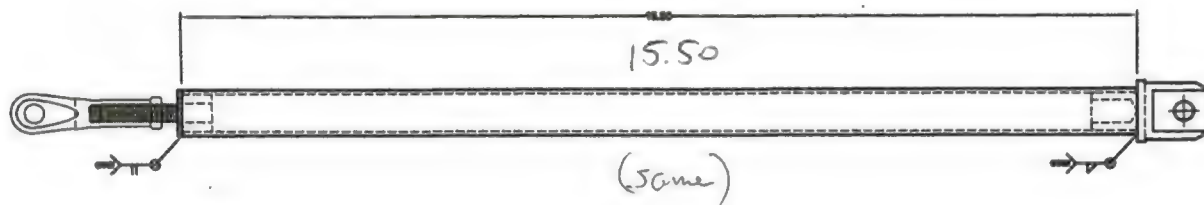
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



2	2	MS21044C3	NUT				
2	2	69830-1032 X 3	C/SUNK SCREW	STAINLESS STEEL	COMMERCIAL		
2	2	69830-23	12 SPRING	STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING	
2	2	69830-22	11 KNOB	B081-T8 ALUMINUM	GO-A-200/8	40 TO 75 ROD	
2	2	69830-10	10 C/STD	B081-T8 ALUMINUM	GO-A-200/8	40 TO 75 ROD	
2	2	69830-11	9 QUIC	304 STAINLESS STEEL	ASTM A269	40 TO 75 X 0.063 ROD TUBE	
1	1	69830-07	08 BLOCK	304 STAINLESS STEEL	ASTM A479	0.188 ROD	
1	1	100630-07	07 CAP	304 STAINLESS STEEL	ASTM A420	1.0 X 0.125 BAR	
1	1	100630-05	06 BRACKET	304 STAINLESS STEEL	ASTM A554	1.2 X 2 X 0.125 TUBE	
1	1	100631-05	05 CAP	304 STAINLESS STEEL	AMS 5515	0.050 SHEET	
1	1	100631-04	04 PLTING	304 STAINLESS STEEL	ASTM A479	1.0 ROUND BAR	
1	1	100633-03	03 TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE	
		100633-01-02	02 RH LFt BEAM (HIGH MOUNT)				
		100633-01-01	01 LH LFt BEAM (HIGH MOUNT)				
02	01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY				LIST OF MATERIALS		

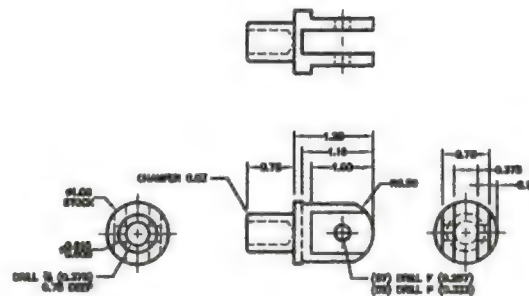
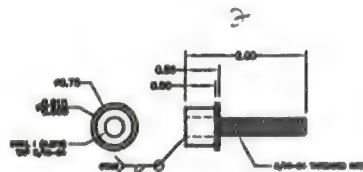
 **AERO DESIGN LTD.**
9588A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL. 504 465.8376 www.aerodesign.ca

BELL 205, 212, 214, 412 SERIES			
QUICK RELEASE MOUNTING PROVISIONS			
AFT BEAM FABRICATION (HIGH MOUNT)			
SCALE 1 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	100633	0



$\phi 3/4 \times 0.065$ 304 S/S
PO 14023

$\phi 3/4$ Solid Rod 304 S/S.
PO 14060



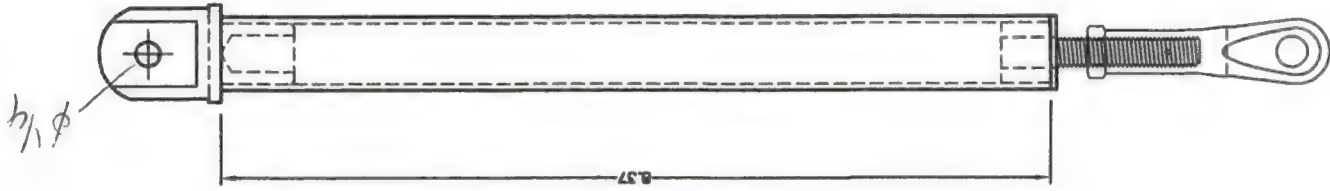
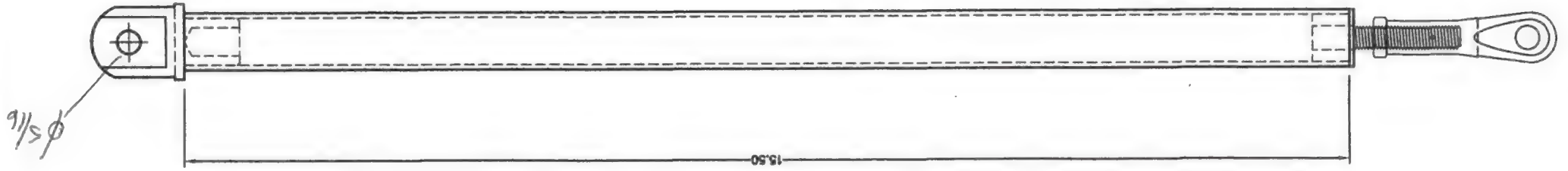
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1			

NO	QTY	PART NO.	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
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2	1	100835-02	EXTERNAL ATTACHMENT PROVISIONS	304 S/S		
3	1	100835-03	EXTERNAL ATTACHMENT PROVISIONS	304 S/S		
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6	1	100835-06	EXTERNAL ATTACHMENT PROVISIONS	304 S/S		
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APPROVALS	DATE
BY CLARK	21 OCT 2014
BY JASON REIVE	

UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES	TOLERANCES ON
DECIMALS	ANGLES
1/16" ± 0.010	1/2"
1/32" ± 0.003	
1/4" ± 0.1	

SCALE	SHEET	REV
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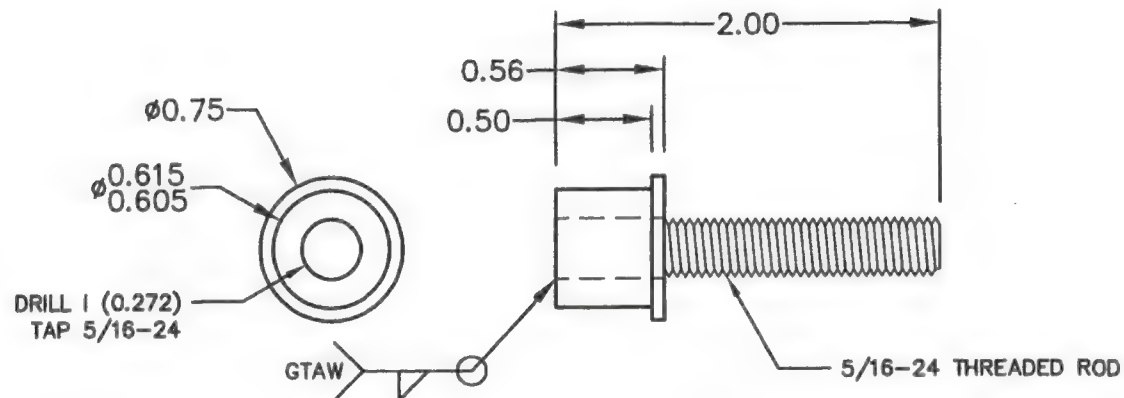
14027
 5/5
 3/4 x 0.065
 14027

Hook Order 2014-75

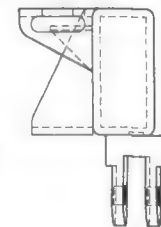
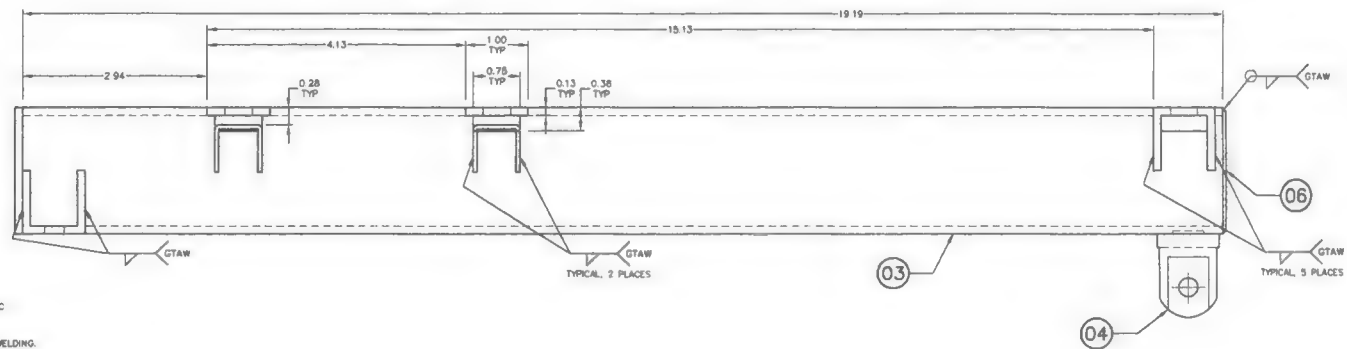
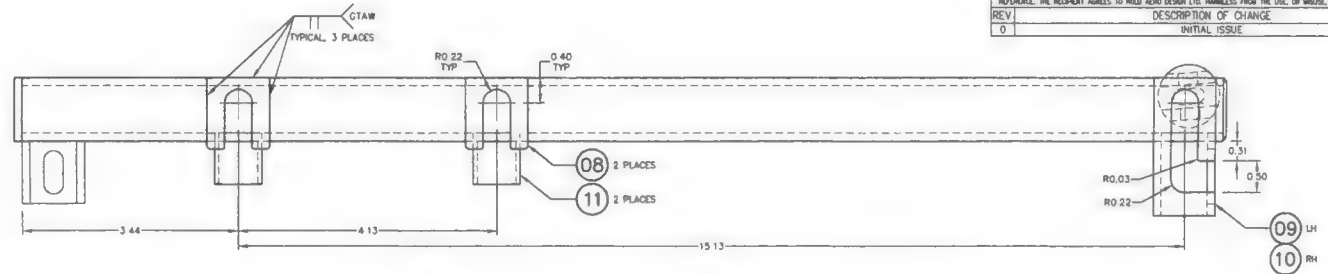
Work Order 2014-75

40+

304 Stainless PO# 14060 3/4" solid round bar.

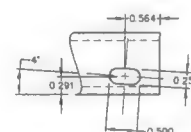
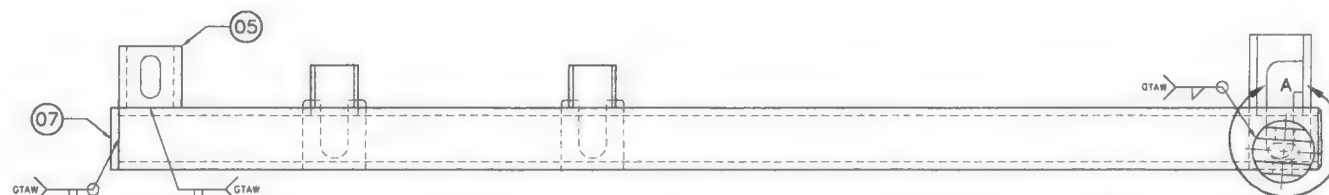


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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2085C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
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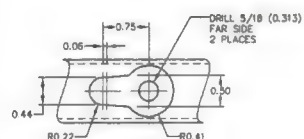


02 RH FORWARD BEAM
01 LH FORWARD BEAM
RH SHOWN, LH OPPOSITE

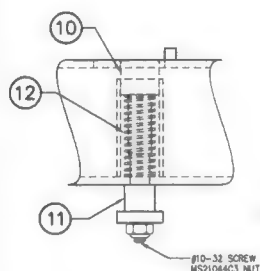
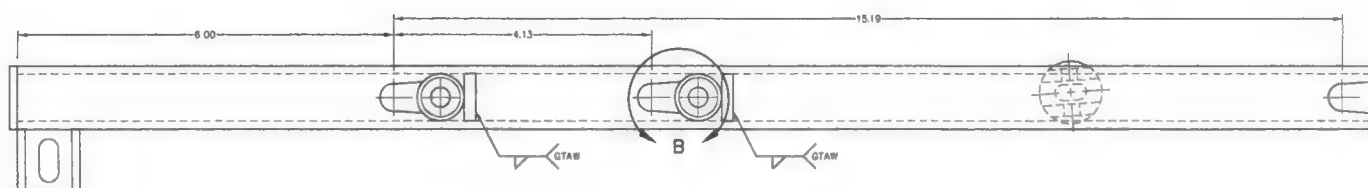
2014-90

QTY	QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	2	78633-05	11	STOP BRACKET	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SQB. TUBE
1		78633-04-02	10	LH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1		78633-04-01	09	RH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
2	2	78633-03	08	GUIDE	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-06	06	CAP	304 STAINLESS STEEL	AMS 5313	0.050 SHEET
1	1	100630-05	05	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100630-04	04	FITTING	304 STAINLESS STEEL	ASTM A479	#10 ROD
1	1	100632-03	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
		100632-01-02	02	RH FORWARD BEAM (HIGH MOUNT)			
		100632-01-01	01	LH FORWARD BEAM (HIGH MOUNT)			

APPROVALS		DATE		AERO DESIGN LTD.	
DRAWN	JEFF CLARKE	18 DEC 2014		9880A MALASPINA ROAD	
CHECKED	JASON REKVE	18 DEC 2014		POWELL RIVER, BC, CANADA, V8A 0G3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				BELL 205, 212, 214, 412 SERIES QUICK RELEASE MOUNTING PROVISIONS FORWARD BEAM FABRICATION (HIGH MOUNT)	
DECIMALS		ANGLES		SCALE 1 1	REV
X.XXX		±0.010		DWG SIZE	DWG NO
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X.X		±0.1		SHEET 1 OF 1	A1 100632 0

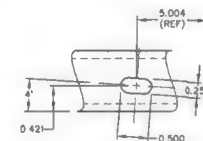
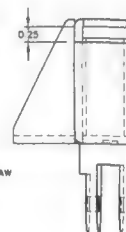
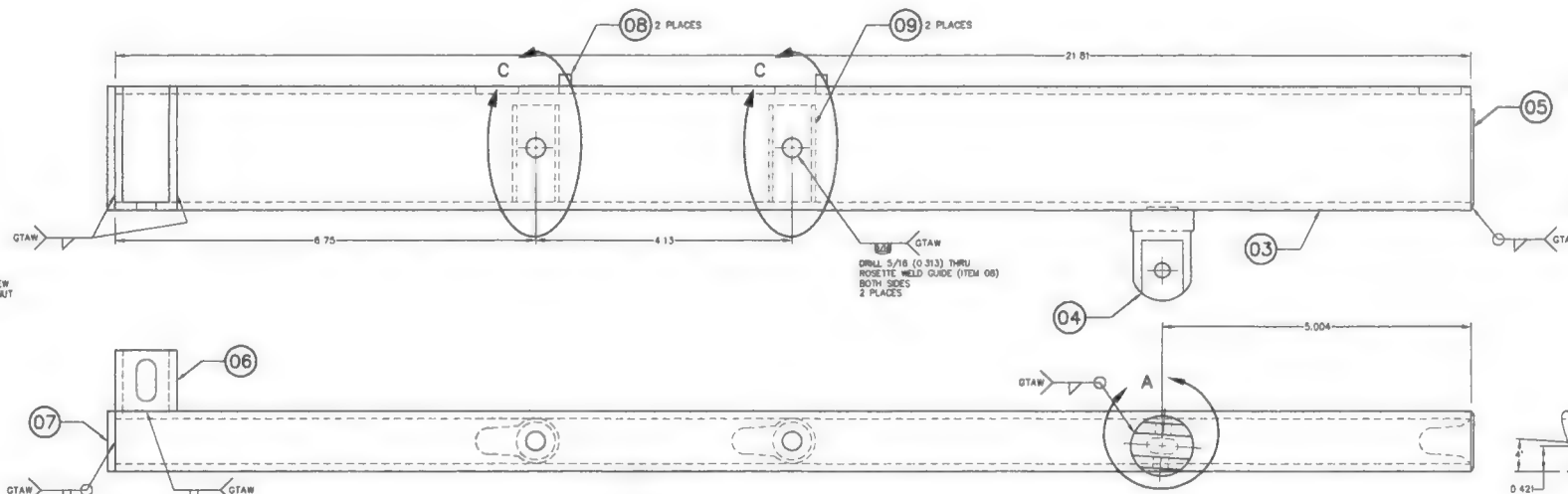


DETAIL 8
TYPICAL, ALL KEYWAYS



DETAIL C

ASSEMBLY AFTER FINISHING
TYPICAL, 2 PLACES



DETAIL A
BEFORE WELDING
SLOT 0.08 DEEP

(02) RH AFT BEAM
 (01) LH AFT BEAM
 RH SHOWN, LH OPPOSITE

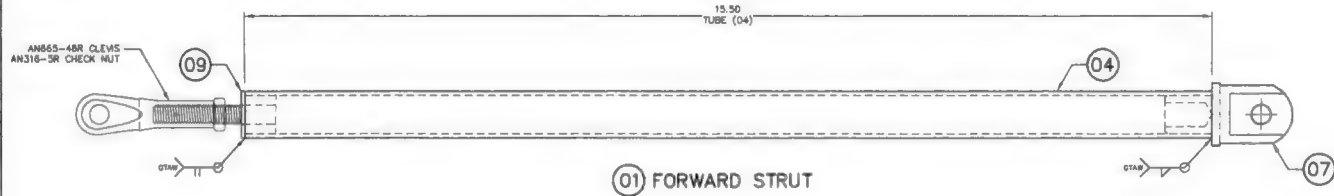
NOTES

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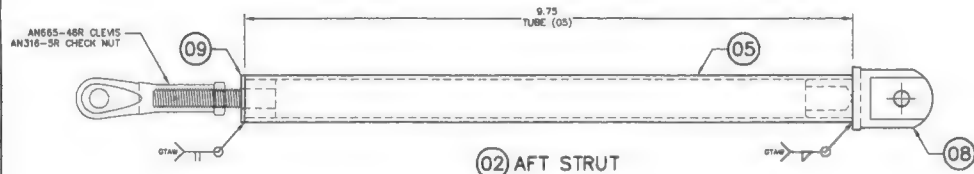
Q2	Q1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	2	MS10044C3		NUT			
2	2	69830-1032 X 3		C'SUNK SCREW			
2	2	69830-23	12	SPRING	STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	2	69830-23	11	KNOR	STAINLESS STEEL		
2	2	69830-21	10	STOP	6081-TB ALUMINUM	00-A-200/8	40 75 ROD
2	2	69830-09	08	STOP	6081-TB ALUMINUM	00-A-200/8	40 625 ROD
1	1	69830-07	06	BLOCK	304 STAINLESS STEEL	ASTM A269	40 75 X 0.063 RND TUBE
1	1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A479	1.00 RND ROD
1	1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A420	1.0 X 0.125 BAR
1	1	100630-05	06	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100631-05	05	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	100631-04	04	FITTING	304 STAINLESS STEEL	ASTM A479	1.0 ROUND BAR
1	1	100633-03	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
		100633-01-02	02	RH AFT BEAM (HIGH MOUNT)			
		100633-01-01	01	LH AFT BEAM (HIGH MOUNT)			
Q2	Q1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
Q2	Q1	QTY			LIST OF MATERIALS		

		APPROVALS		DATE			AERO DESIGN LTD.		
DRAWN:		JEFF CLARKE		18 DEC 2014			9888A MALASPINA ROAD		
CHECKED:		JASON REKVE		18 DEC 2014			POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 250-488-5575 www.aerodesign.ca		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:							BELL 205, 212, 214, 412 SERIES QUICK RELEASE MOUNTING PROVISIONS AFT BEAM FABRICATION (HIGH MOUNT)		
DECIMALS		ANGLES							
X XXX ±0.010		±1/2°							
XX ±0.03									
X ±0.1									

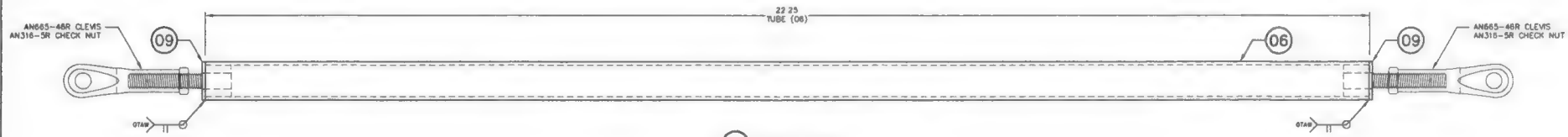
REV		DESCRIPTION OF CHANGE	INITIALS	DATE
0		INITIAL ISSUE		



01 FORWARD STRUT



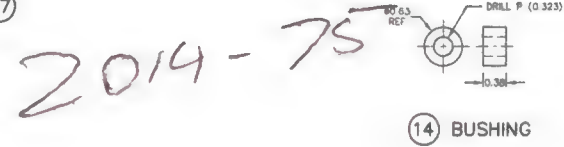
02 AFT STRUT



03 DRAG LINK

NOTES

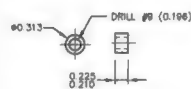
- 1 REMOVE ALL BURRS AND BREAK SHARP EDGES.
- 2 WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- 3 THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ALL PARTS AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL PARTS AFTER WELDING. DO NOT PAINT/POWDER COAT THREADED RODS. ASSEMBLE HARDWARE AFTER PAINT/POWDER COAT.



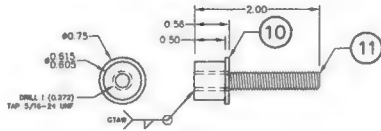
14 BUSHING



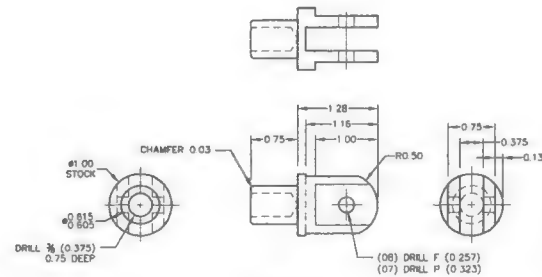
12 BUSHING



13 BUSHING



09 THREADED ROD END



08 FITTING

07 FITTING

07 AND 08 IDENTICAL EXCEPT FOR HOLE AS NOTED

QTY	QTY	QTY	QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	1	1		AN315-SR	CHECK NUT				
2	1	1		AN315-48R	CLEVIS ROD END				
				100635-14	14	BUSHING	304 STAINLESS STEEL	ASTM A479	#0.625 ROD
				100635-13	13	BUSHING	BRASS	ASTM B927	#0.315 ROD
				100635-12	12	BUSHING	BRASS	ASTM B927	#0.375 ROD
1				100635-11	11	THREADED ROD	304 STAINLESS STEEL	ASTM F303	5/16-24 THREADED ROD
1				100635-10	10	THREADED BUSHING	304 STAINLESS STEEL	ASTM A479	#0.75 ROD
2	1	1		100635-09	09	THREADED ROD END	304 STAINLESS STEEL	ASTM A479	#1.0 ROD
				100635-08	08	FITTING	304 STAINLESS STEEL	ASTM A479	#1.0 ROD
				100635-07	07	FITTING	304 STAINLESS STEEL	ASTM A479	#1.0 ROD
1				100635-06	06	TUBE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
1				100635-05	05	TUBE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
1				100635-04	04	TUBE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
				100635-03	03	DRAG LINK			
				100635-02	02	AFT STRUT			
				100635-01	01	FORWARD STRUT			

APPROVALS		DATE	AERO DESIGN LTD. 9880A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804 680 8376 www.aerodesign.ca
DRAWN: JEFF CLARKE		18 DEC 2014	
CHECKED: JASON REKVE		18 DEC 2014	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		DECIMALS ±0.010 X .XX ±0.03 X X ±0.1	
ANGLES ±1/2°		SCALE 1 : 1	REV
SHEET 1 OF 1		A1	100635 0



WO# 2014-90

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

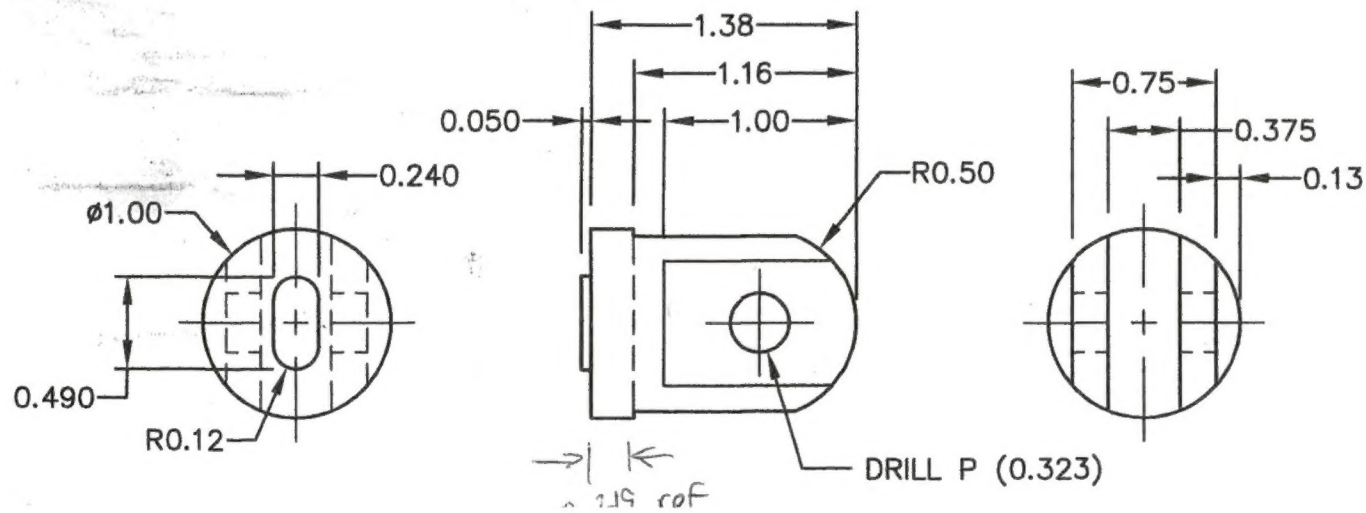
B212 Mega

~~2014-75~~

2014-90

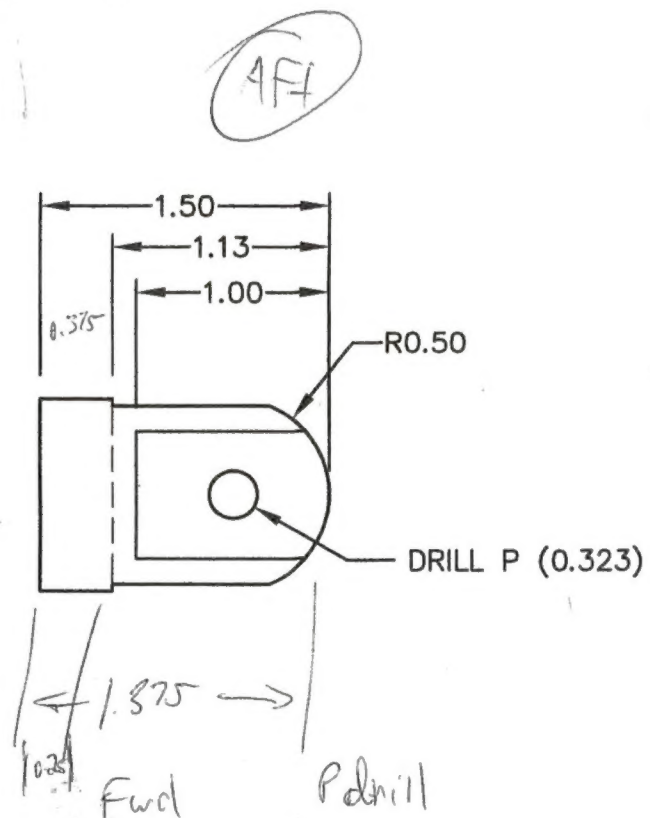
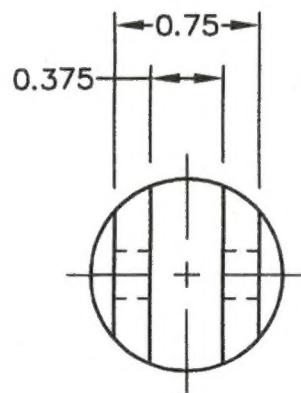
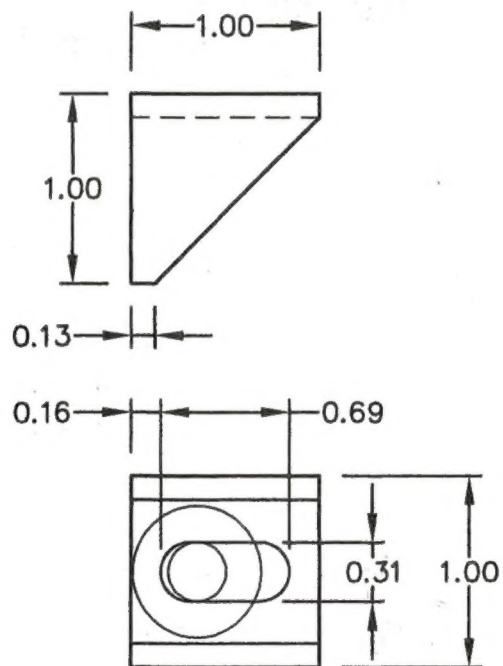
φ1.0 304 s/s

9501112



2x

9501112 1.0 ϕ
304 Stainless

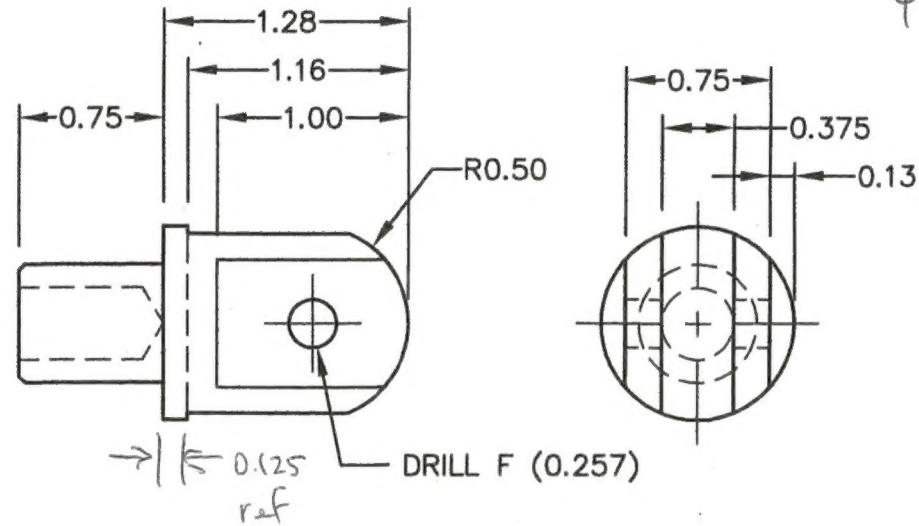
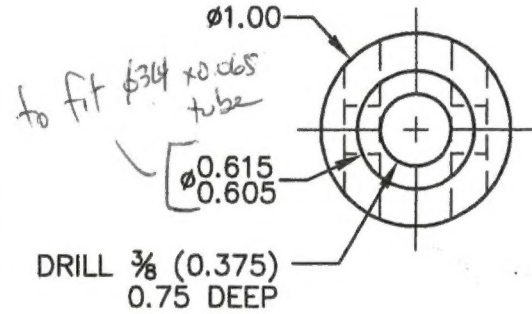


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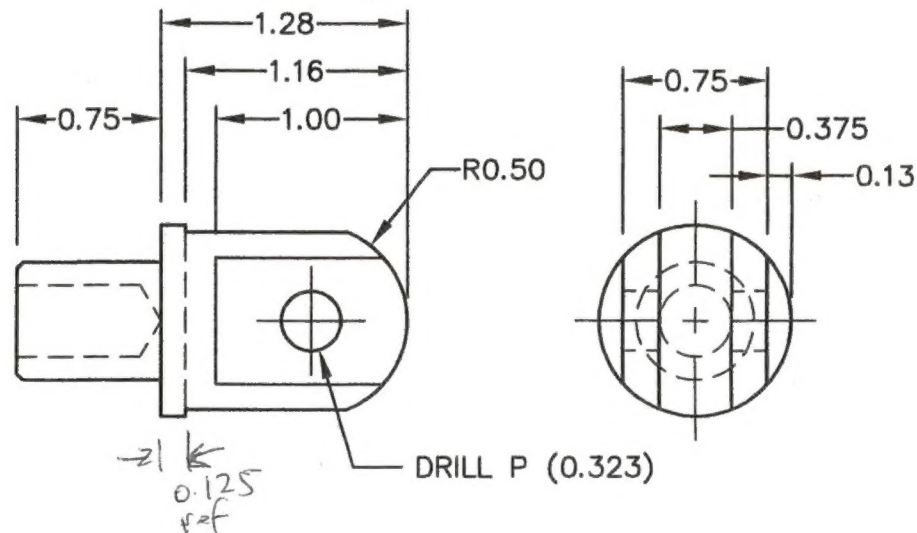
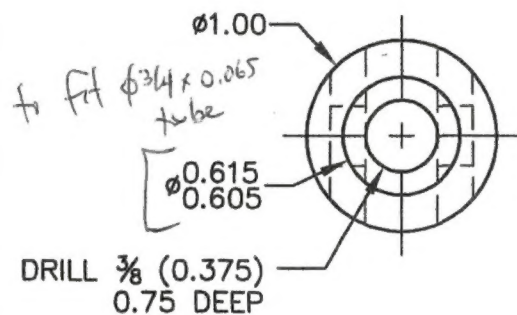
2014-75

Ø1.0 304 S/S
950112

Ø1.04



1x



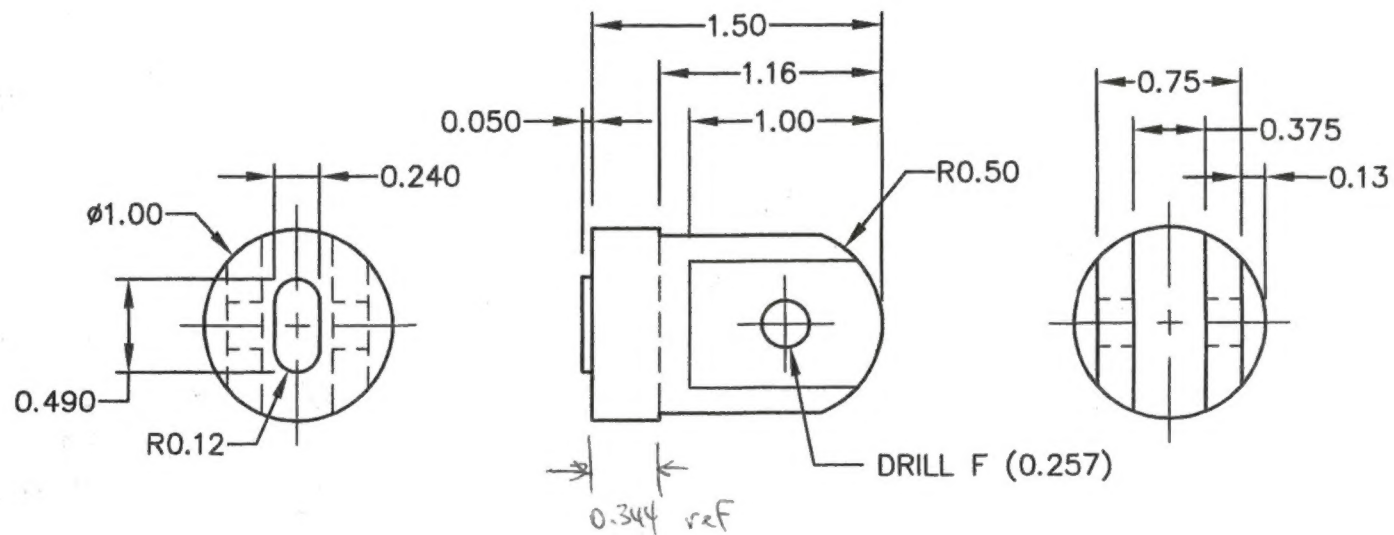
1x

B212 Mega

2014-75

φ1.0 304 s/s

9501112



2x